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DART AEROSPACE LTD	Work Order:	21385
Description: Bracket Assembly	Part Number:	D3183-041
Dwg: D3183 Rev. A page 1, 2, 4	Qty:	D3183-042
RF 03.10.02		4 Kits

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	RF	03.10.02	4
2	MV	Cut (1) blank per D3183-041 & (1) blank per D3183-042 Cut blanks (2.00" x 1.50") x 4.30" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B2.000x01.500) Batch: 114579	RF	03.10.02	4
3	MV	Machine D3183-1 as per Folio FA320 and Dwg D3183	RF	04.11.24	4
4	QC2	Inspect parts as they come off the CNC machine	RF	04.11.24	4
5	MV	Machine D3183-2 as per Folio FA320 and Dwg D3183	RF	04.11.24	4
6	QC2	Inspect parts as they come off the CNC machine	RF	04.11.24	4
7	MV	Deburr Break all sharp edges 0.005 to 0.015	RF	04.11.24	4
8	MV	Scribe batch number to D3183-1 & D3183-2 as per Dwg D3183	RF	05.01.20	4
9	QC5	Second check D3183-1 and D3183-2	RF	05.01.24	4
10	GA	Assemble D3183-041 as per Dwg D3183 Pick: 2 D3183-045 bearing Qty Part Number Description Batch 2 D3121-17 Washer 4 D3183-5 Bearing 2 D3183-7 Washer 2 MS24694-S50 Screw 2 D3121-21 Screw	RF	05.01.24	4
11	GA	Assemble D3183-042 as per Dwg D3183 Pick: Qty Part Number Description Batch 2 D3121-17 Washer 4 D3183-5 Bearing 2 D3183-7 Washer 2 MS24694-S50 Screw	RF	05.01.24	4
12	QC5	Inspect work to Step 10 & 11	RF	05.01.20	4
13	ST	Identify and Stock in Spacedoor cell	D3183-041 Qty 4 D3183-042 Qty 8	RF	05.01.22
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part 126.50	540	05.01.27	4
15	DC	Close W/O 170.90 Inspect Level 21	RF	05.02.21	4

Rev	Date	Change	Revised By	Approved
A	03.03.28	New issue	KJ/RF	RF

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	
01.12.06.	10	<i>Permanen t Change</i>	<i>JS</i>	05.01.08	N/A	<i>BS</i> Pending	<i>BS</i> 05.02.08	

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____

Fault Category: _____

DQA: _____

Date: _____

DART AEROSPACE LTD		Work Order:	21385
Description: Washer		Part Number:	-D3183-7
Inspection Dwg: D3183	Rev: C		D3183-1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.052	+/-0.005					
0.600 ^{0.400}	+/-0.010	0.401	✓			
0.394	+0.005/-0.000					
0.182	± 0.01	0.184	✓			
0.070	"	0.069	—			
0.100	"	0.101	✓			
R.063	"	R.063	✓			
R.188	"	R.188	✓			
3.881	"	3.884	✓			
4.17	± 0.03	4.164	✓			
0.830	± 0.01	0.835	✓			
0.500	"	0.501	✓			
0.218	"	0.216	✓			
1.030	"	1.035	✓			
1.90	± 0.03	1.891	✓			
1.012	± 0.01	1.008	✓			
0.786	"	0.787	✓			
R.19		R.188	✓			
ϕ .392	± 0.002 ~ 0.000	ϕ .3927	—			
0.162	± 0.01	0.160	✓			
2.799	"	2.804	✓			
2.075	"	2.080	✓			
0.162	"	0.162	✓			
0.032	"	0.026	✓			
0.381		0.384	✓			
0.200		0.201	✓			

Measured by:	EC	Audited by:	JKL	Prototype Approval:	N/A
Date:	04.11.23	Date:	04.11.23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-041/-042)	KJ/RF	RF

RELEASED

04.11.26

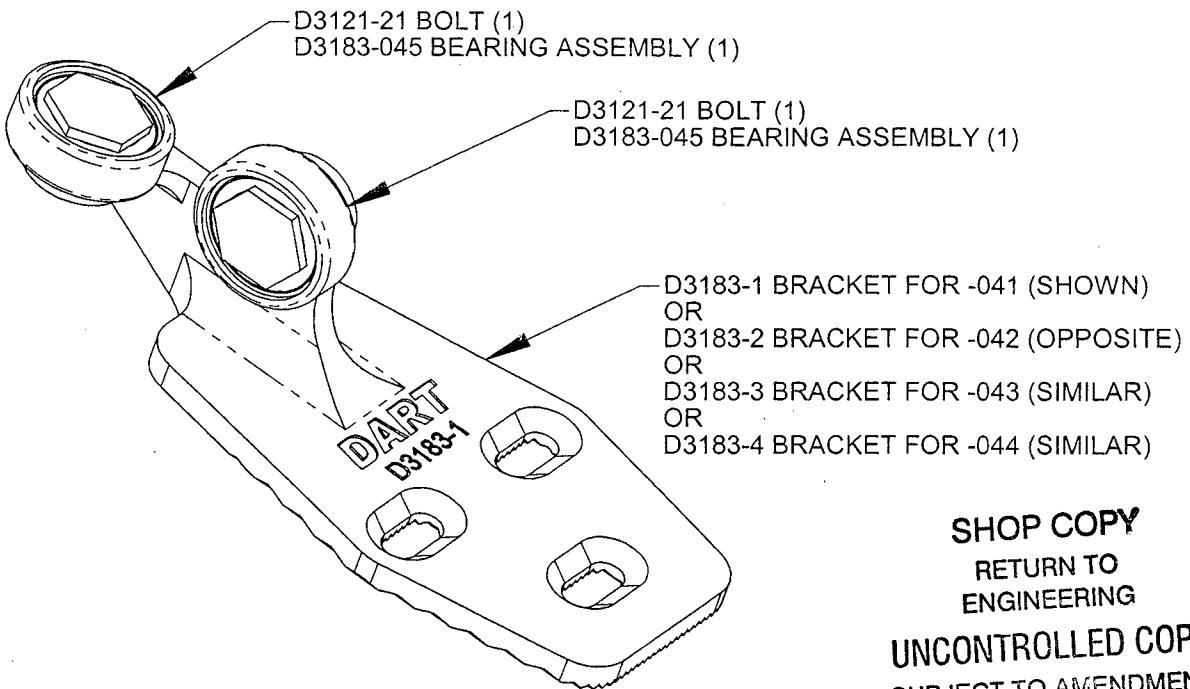


COPY IS
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	04.02.17	TITLE	SCALE 1:1

RELEASED
04.03.01

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

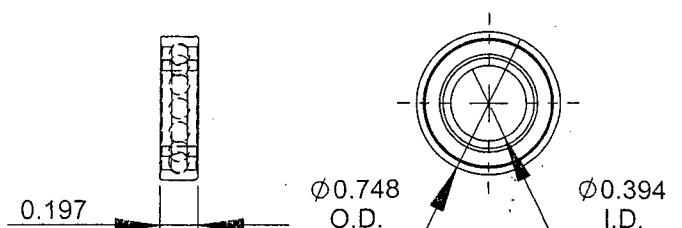
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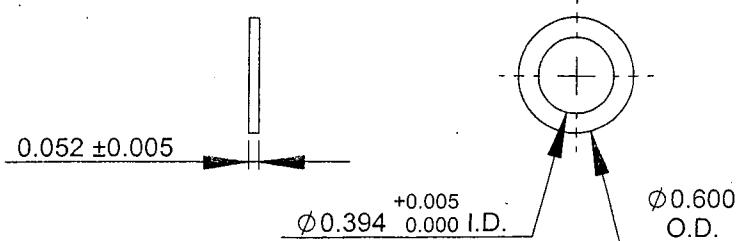
WORK ORDER

NO. 21385



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

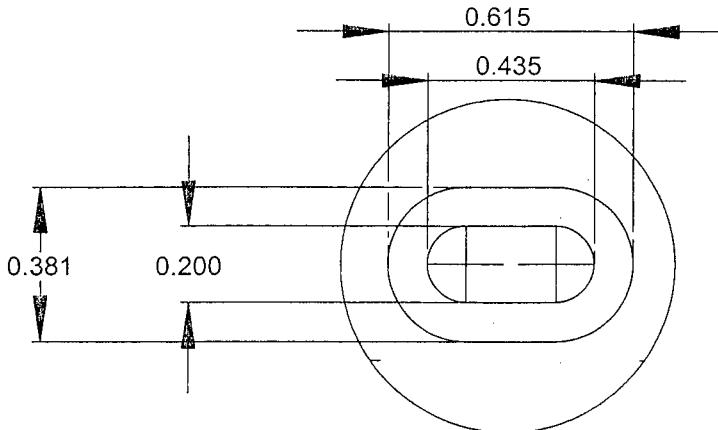
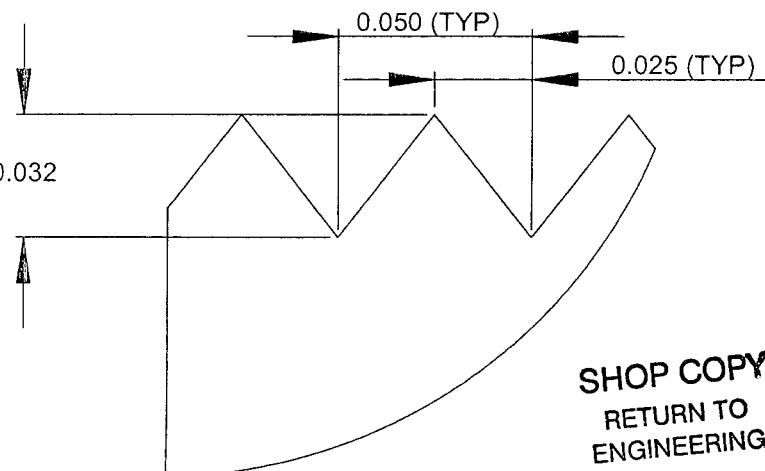
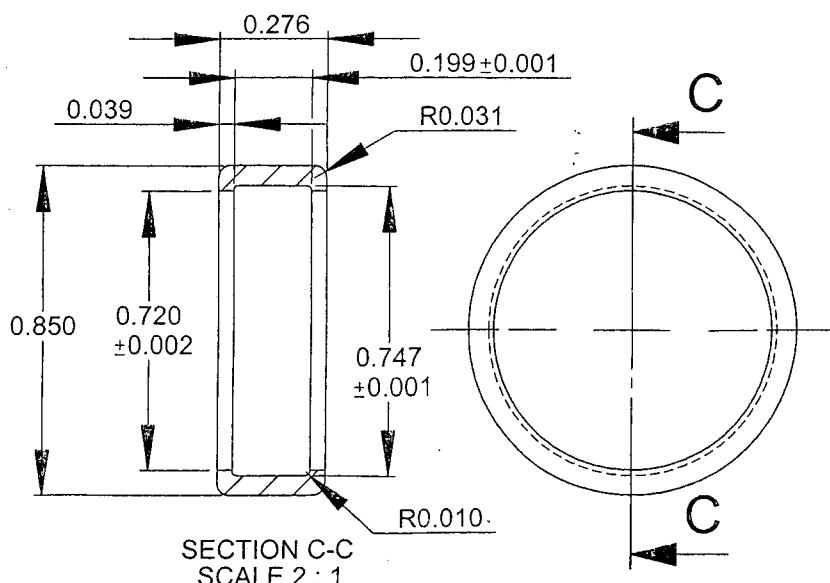
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE		DRAWING NO. D3183	
04.02.17		TITLE	SCALE 1:1

DETAIL A (2 : 1)**RELEASED**
04.03.01DETAIL B (20 : 1)SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
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WITHOUT NOTICEWORK ORDER
NO. 21385SECTION C-C
SCALE 2 : 1D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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Job Costing Report

Dart Aerospace Ltd.
HawkesburyAug 23, 2004
09:51 am

Work Order No : 0021385
 Project Name : D3183-041
 Project For : WK440
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3183-041
 Description : Bracket Assembly
 Manufactured : Yes
 Amount Req'd : 4
 Amount Done : 0
 Start Date : 08-23-04
 Est Finish Date : 09-21-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00